

Date: Friday, 7/21/2006 7:37:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 28022
 Estimate Number : 10008
 P.O. Number : *N/A*
 This Issue : 7/21/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 27923
 Written By : *See comment below*
 Checked & Approved By : *06.07.21*
 Comment : Est Rev: Removed from 9 Digit 05-10-25 JLM

Part Number : D2591
 Drawing Number : D2591 REV D
 Project Number : N/A
 Drawing Revision : D
 Material : *N/A*
 Due Date : 8/9/2006

Qty: *86* Um: *80* Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010B0750X02500 ASTM A21 Steel .75"x2.5"



Comment: Qty.: 0.2340 f(s)/Unit Total : 18.7200 f(s)
 ASTM A36 Steel bar 2.50" x 0.75" thick (M1010-B0.750X02.500)
 Batch: *M100283*

ml 06/02/27 86

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 2.700" long

ml 06/07/27 86

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

ml 06/07/28 84

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/07/28 84

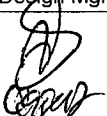

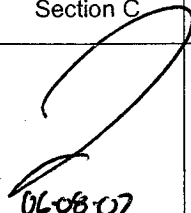
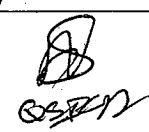
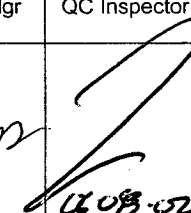
5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 06/08/02 84

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---|----------------------------------|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 06/07/28 | 3 | 2 piece pop outside of the vice. Parts scrap. |  | destroy NO replace. |  06/08/02 |  06-08-02 |  06-08-02 |  06-08-02 |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/03

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 7/21/2006 7:37:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 28022

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

(84)

06/08/01

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(84)
06/08/03

Job Completion



06/08/02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

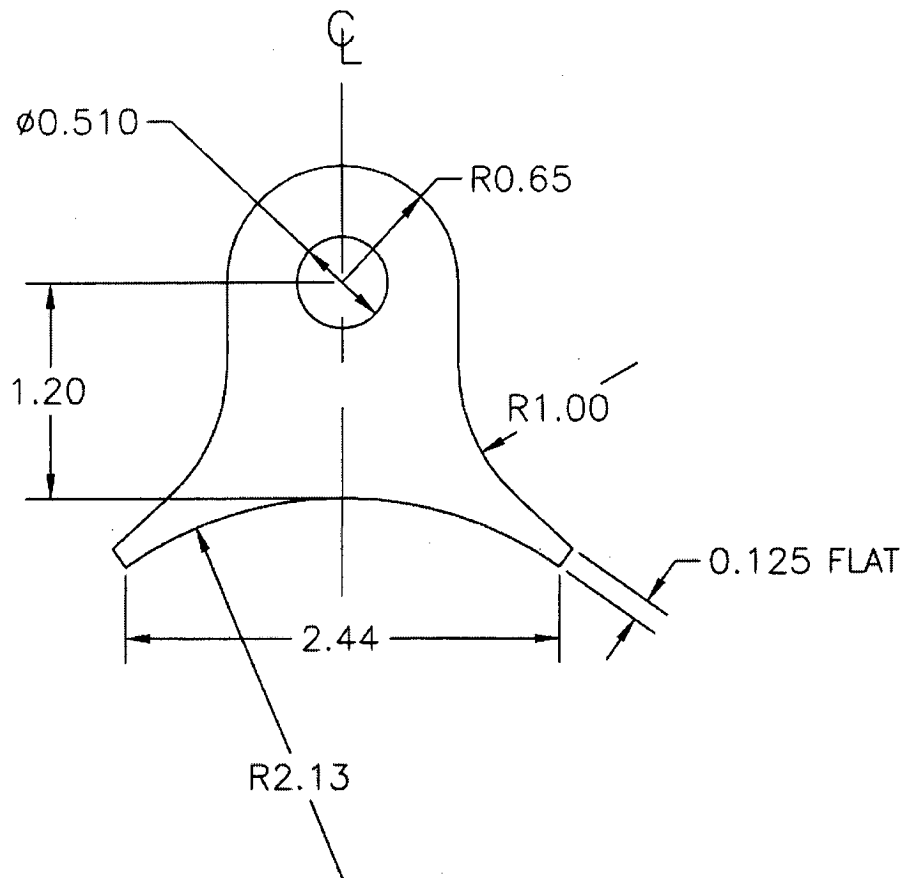
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|----------------------|------------------------|--|------------------------|
| DESIGN <i>MEY</i> | DRAWN BY <i>MEY</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>BW</i> | DRAWING NO. D2591 | REV. D SHEET 1 OF 1 |
| DATE 98.01.21 | | TITLE GHW LUG | SCALE 1:1 |
| A | 96:09:16 | NEW ISSUE | |
| B | 97:06:17 | RE-DESIGN TO FLAT BOTTOM | |
| C | 97.12.12 | RE-DESIGN TO RADIUS BOTTOM | |
| D | 98.01.21 | 0.125 FLAT WAS 0.067 FLAT | |

RELEASED
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28022